

Date: Tuesday, 20/05/2008 11:50:34 AM
User: Melanie Fauteux

Process Sheet

D412-761-09.

Customer : CC-DAR01 Dart Aerospace Ltd. **Drawing Name** : INITIAL PROTOTYPE TEMPLATE
Job Number : 00224A
Estimate Number : 10068
P.O. Number :
This Issue : 20/05/2008 **S.O. No.** :
Prsht Rev. : NC
First Issue : / / **Type** : R & D SM/MED FAB
Previous Run : 00223A
Written By : _____
Checked & Approved By : _____ MF
Comment : Project #: _____
 Description: _____

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MFG ENGINEERING	MFG ENGINEERING
		
Comment: MFG ENGINEERING		
Manufacture Prototype as per Dwg's Supplied By Engineering		
Comments:		
-	MS 24 693 C 276	M 3459
-	QTY 5	
-	NAS 1515 H 6 L	M 18918
-	QTY 2	
-	MS 24 665 285	M 9003
-	QTY 1	
-	AN 6-26	M 108810
-	QTY 1	
-	AN 960 SD 616 L	M 102630
-	QTY 1	
-	AN 310-6	M 105279
-	QTY 1	
-	D 3694-041	B 38771
-	QTY 1	
-	D 3695-1	B 38695
-	QTY 1	
-	D 3695-2	B 38721
-	QTY 1	
-	WIP-510	M 107731
-	QTY 2	
-	D 3694-041	B 34005
-	QTY 1	
-	D 3781-041	B 34031
-	QTY 1	
-	D 3781-041	B 34035
-	QTY 1	

Comment: PURCHASING

Attached certificate of conformity for raw material and subcomponents use for this w/o

- H521209 - F-20 B/N 104537 (H51-C01) ADP
- A15261032 RA H101189 (S50W) parts + ADP warrant

* The following parts were altered from original design and
removed in a modified position to reduce weight.

- D3781-3: cutaway pocket/slot to reduce weight.
- D3781-1: added pocket to reduce weight and provide means to
install and remove parts.

* Installed/reduced D3785-1 ~~sheath~~ on D3785-2. MADE from Blk M1770
Paw Bar.

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Drawing Name: INITIAL PROTOTYPE TEMPLATE

Job Number: 00224A

Part Number: INITIAL PROTOTYPE

Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

INSTALL THE ARM REST MOUNT

D412-761-019

INSTALL CHERRY MAX RIVETS

CR 3212-4-02 B/M107394

QTY 12

CR 1122-3-025 B/M106878

QTY 22

INSTALL PLATE NUTS

MS 21075 L3 B/M107279

QTY 10

~~MS 21071 L3 B/M102589~~

QTY 43

INSTALL MOUNT

AN 3-11 A M14820

QTY 10

AN 9605 D 10 M107799

QTY 10

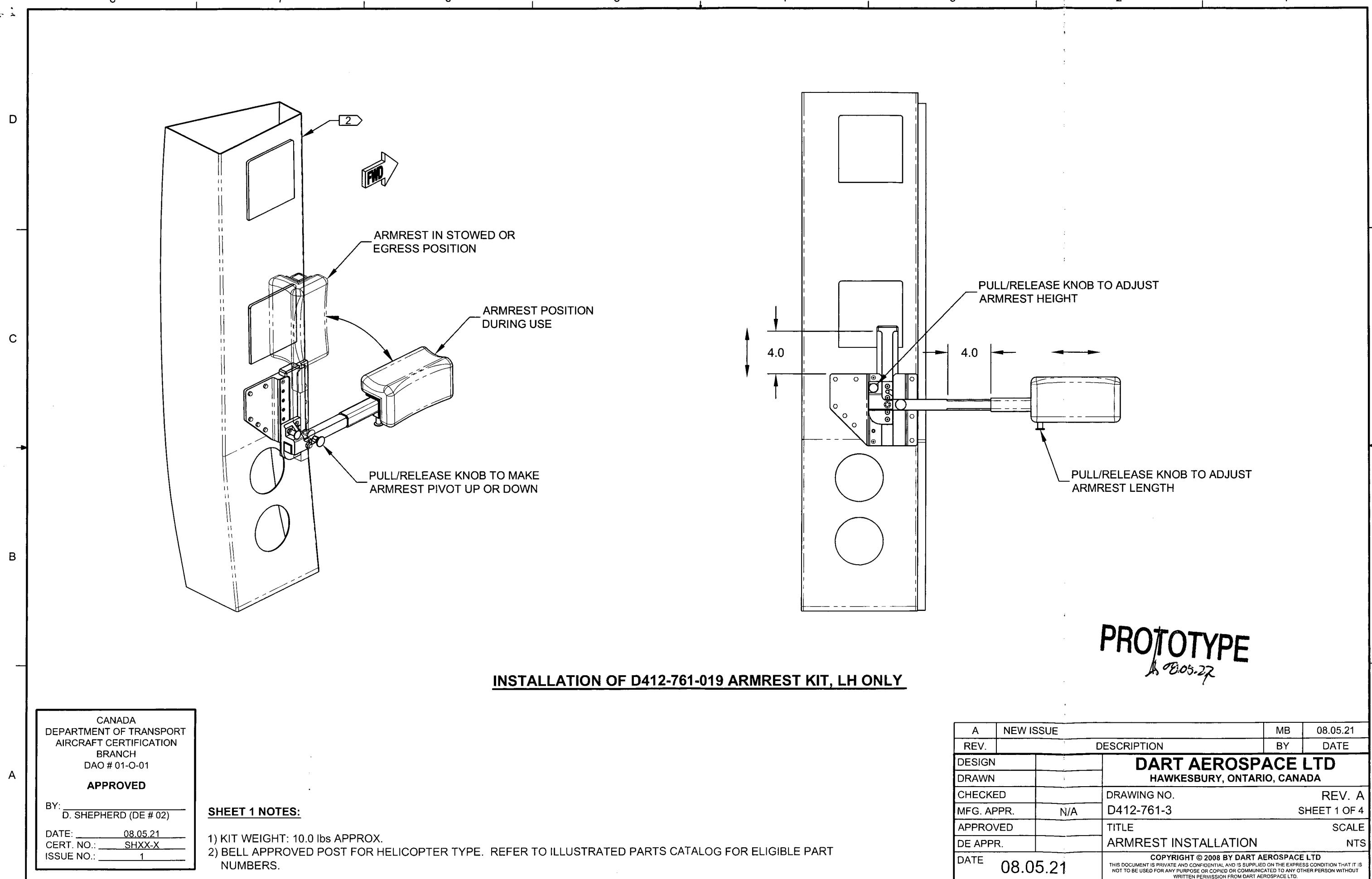
AN 3-6 A M106662

QTY 10

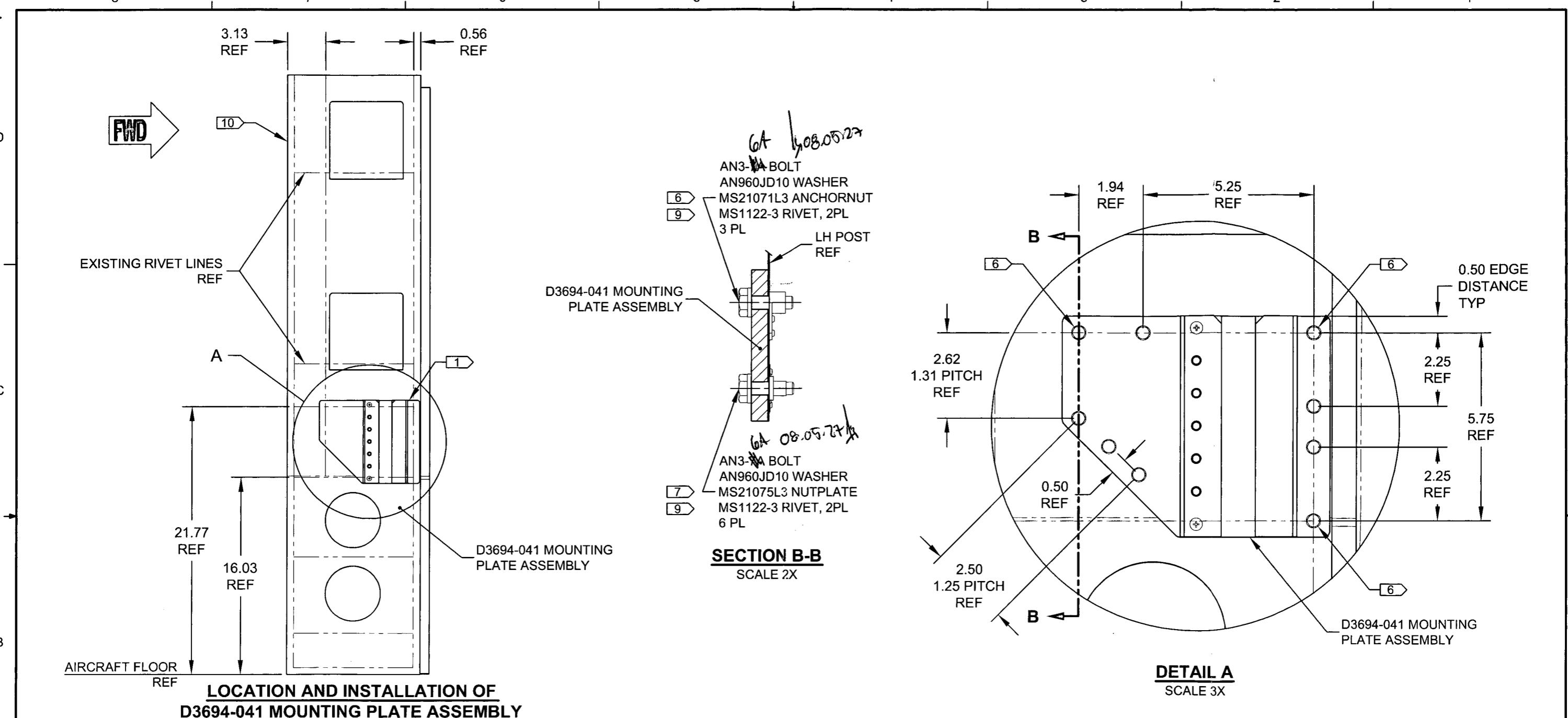
Job Completion



— MFG. Shim M6061T6S050 M104186 ← NOT
REQ'D. 08/05/27



8 7 6 5 4 3 2 1



LOCATION AND INSTALLATION OF D3694-041 MOUNTING PLATE ASSEMBLY

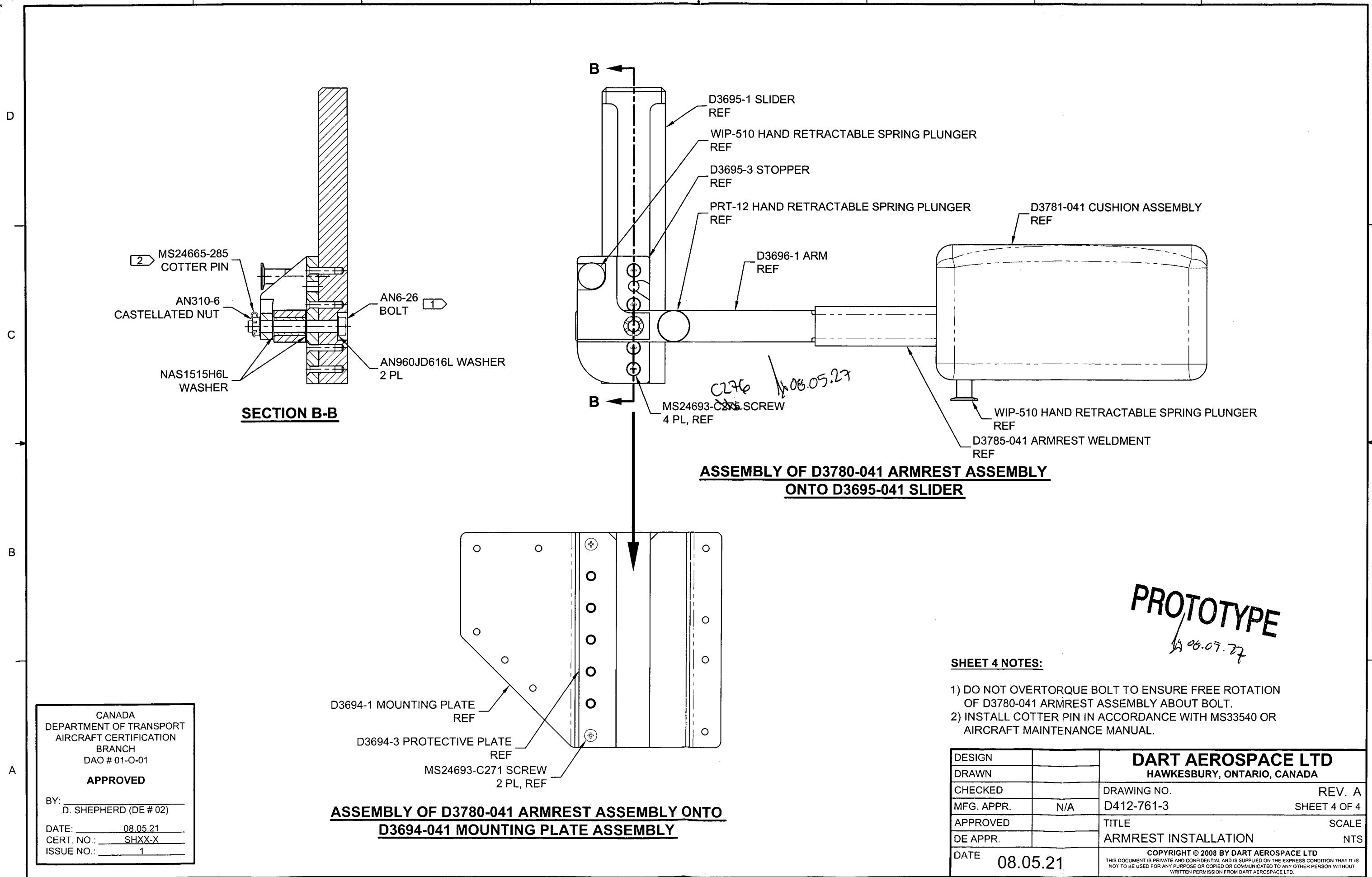
SHEET 2 NOTES:

- 1) DRAW PERIMETER OF D3694-041 MOUNTING PLATE ASSEMBLY ON LH POST AS SHOWN ABOVE.
- 2) ON LH POST, REMOVE EXISTING RIVETS THAT ARE WITHIN AREA MARKED AT STEP 1.
- 3) LOCATE BOLTS ON EXISTING RIVET LINES PER DETAIL A. IT IS ACCEPTABLE TO DEVIATE FROM THE BOLT PATTERN SHOWN IN DETAIL A TO ENSURE THAT THE INSTALLATION OF NUTPLATES/ANCHOR NUTS IS NOT CONFLICTING WITH EXISTING HOLES.
- 4) ENLARGE RIVET HOLES THAT WILL BE SUBSTITUTED BY AN3 BOLTS TO Ø0.209".
- 5) REPLACE RIVETS REMOVED AT STEP 2 THAT WILL NOT BE SUBSTITUTED BY BOLTS USING CR3212 RIVETS OR EQUIVALENT.
- 6) INSTALL MS21071L3 ANCHORNUTS ON LH POST PER DETAIL A AND SECTION B-B USING MS1122-3 RIVETS OR EQUIVALENT.
- 7) INSTALL MS21075L3 NUT PLATES ON LH POST PER DETAIL A AND SECTION B-B USING MS1122-3 RIVETS OR EQUIVALENT.
- 8) TRANSFER DRILL Ø0.209" HOLES FROM LH POST TO D3694-041 MOUNTING PLATE.
- 9) AFTER PAINTING, INSTALL D3694-041 MOUNTING PLATE ASSEMBLY USING AN3-10 BOLTS AND AN960JD10 WASHERS. TORQUE BOLTS TO 25 in-lb (3 N-m). *6A 08.05.27*
- 10) BELL APPROVED POST FOR HELICOPTER TYPE. REFER TO ILLUSTRATED PARTS CATALOG FOR ELIGIBLE PART NUMBERS.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01
APPROVED
BY:
D. SHEPHERD (DE # 02)
DATE: 08.05.21
CERT. NO.: SHXX-X
ISSUE NO.: 1

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. A
MFG. APPR.	N/A	D412-761-3
APPROVED		SHEET 2 OF 4
DE APPR.		TITLE
DATE	08.05.21	SCALE
		NTS
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8 7 6 5 4 3 2 1



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